



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4060-1

Job Sheet 172958



Part No: D4060-1

Job Qty: 20 ea

Part Name: Ski Clamp, Top



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV C IPP Rev:A new issue DD 10.02.16 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/3/18	3/3/18	0.00	0.00	Start Up Waterjet		20 18/03/25
100	Waterjet	20 pcs	3/3/18	3/3/18	0.00	1.33	Waterjet1		20 18/03/25
120	QC	20 pcs	3/3/18	3/3/18	0.00	0.00	QC8		38
130	Brake NC	20 pcs	3/5/18	3/5/18	0.01	1.04	Brake NC 1		38
140	QC	20 pcs	3/5/18	3/5/18	0.00	0.00	QC5		38
150	Packaging	20 pcs	3/5/18	3/5/18	0.00	0.00	Packaging3		38
160	QC21-SA	20 Ea	3/5/18	3/5/18	0.00	0.00	QC21		38

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	1.7000 sf (.085 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	2	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Ski Clamp, Top	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
2	Ski Clamp, Top	0.328Inches ± 0.010	0.338 0.318		
3	Ski Clamp, Top	0.375Inches ± 0.010	0.385 0.365		
4	Ski Clamp, Top	0.750Inches ± 0.030	0.780 0.720		
5	Ski Clamp, Top	1.000Inches ± 0.030	1.030 0.970		
6	Ski Clamp, Top	8.922Inches ± 0.010	8.932 8.912		
7	Ski Clamp, Top	9.790Inches ± 0.030	9.820 9.760		



Container No: S054613

Part: D4060-1

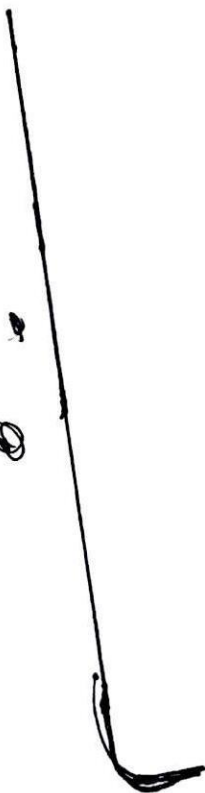
Job No: 172958

Serial No/Batch: S054613

Revision:
Inspector:

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Date: 03/25/18



8

7

6

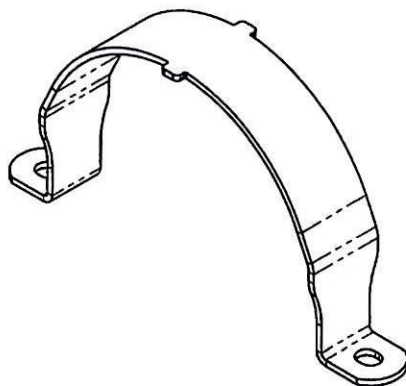
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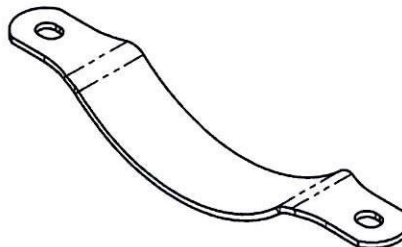
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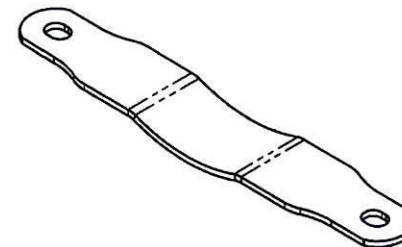
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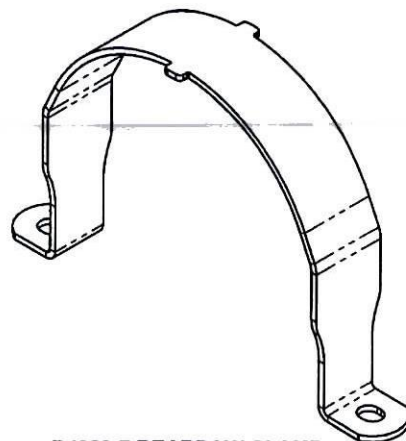
D4060-1 412 SKI CLAMP, TOP



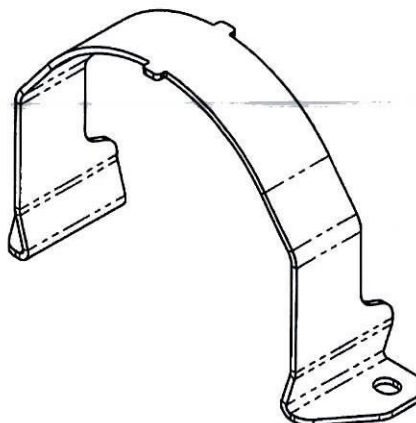
D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT



D4060-7 BEARPAW CLAMP



D4060-9 AFT BEARPAW CLAMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

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WORK ORDER
NO. 172958

20180226

C	ADD -7 & -9. REASON: CIR16-67. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP, REASON: PAR 14-368, PAR 14-331, NCR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
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RELEASED
2016-10-18
ECN 16-654

APPROVED

NO. 172958
20180226



RELEASE
2016-10-18

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 2 OF
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DE APPR.	DS	412 SKI CLAMP	NTS
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